

Work Order ID 76603

76603

Page 1

November-18-11 9:14:18 AM

Item ID: D206-642-151

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Replacement Skidtube

Start Date: 18/11/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 16/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: M.C.S

Date: 11/11/11 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D3804 | A | | | | | | | | |
| HN-D206-642 | O | | | | | | | | |

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D206-642-151

CHG001

N/A

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
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NOTE: Date & initial all entries

Work Order ID 76603***76603***

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Item ID: D206-642-151

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N900040100Setup Start ***NS1***

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1

Cust Item ID:

Required Date: 16/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

110

0.00

110

Skidtubes

Skidtubes

Memo

0.00

1-Deburr Fwd edge of tube

2- Remove ridge on inside of Fwd edge of tube as per Dwg D3804

3-Weld Fwd Cap as per Dwg D3804. Use aluminum rod. Grind D2647 to fit as required.

Pick:

Qty Part Number DescriptionBatch

A/R Aluminum Rod *m117009**7 BE 11-12-23*

4-Grind weld flush to cap on top surface only.

5-Cut Aft end as per dwg D3804 from front of tube and Deburr

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D3804

7-Open holes for Aft end cap as per Dwg D3804 with #30 Drill Bit using DT8025.

8-Drill pilot holes using Dt8166 & DT8169D & DT9771.

9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support.

10- Drill D3286-1 doubler rivet holes in tube using # 30 drill, spot drilling doubler at the same time.

*X BB SS 11/12/22**SAD 11-12-27**SAD 11-12-27*

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 76603

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November-18-11 9:14:18 AM

Item ID: D206-642-151 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Replacement Skidtube
 Start Date: 18/11/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 16/01/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.

12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D3804

13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder

14-Remove indexing edge using DT8741 as per Dwg D3804

15-C'sink GHW rivet holes as per Dwg D3804

16- Open Aft cap hole #6.
 ****no wearplate holes for this skidtube****

17-Deburr tube and blow out chips from inside the tube

120

120

QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

Memo

0.00

8 11/12/28

PK 11/12/28

SAD 11-12-27

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Item ID: D206-642-151

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N900040100Setup Start ***NS1***

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Item Name: Replacement Skidtube

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Cust Item ID:

Required Date: 16/01/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

140 Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

① SFD 11-12-28

150 QC3- Inspect Part Finish

0.00

150

QC

Memo

0.00

Quality Control

1 OK BK 11-12-28

160 Skidtubes

0.00

160

Skidtubes

Memo

0.00

Skidtubes

1-Open holes to finished size as per Dwg D3804, (without cutting fluid)

2-C'sink crossbolt spacer holes as per Dwg D3804(without cutting fluid)

3-Deburr and blow out all chips from inside the tube

OK 11/12/28

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NS1

Revision ID:

Item Name: Replacement Skidtube

Stop

NS2

Start Date: 18/11/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 16/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

QC6- Inspect dimensions to drawing

0.00

170

QC

Memo

0.00

Quality Control

1 0 0611-12-28

180

Skidtubes

0.00

180

Skidtubes

Memo

0.00

Skidtubes

1-Locate, install and rivet doublers as per Dwg D3804. Micro-shave rivets as required

2-Bond D2654-1 web in place as per QSI 015. Ensure holes line up.Allow 12

Hrs. cure time before cutting

Start Date: 11-17-28 Time: 4h30

Finish Date: 12-01-02 Time: 2:00

Pick:

Qty Part NumberDescriptionBatch

A/RSikaflex-291 7119508

Sikaflex expire date: 2012/08/13

1 6 342 11-12-28

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Replacement Skidtube

Start Date: 18/11/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 16/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.00

Quality Control

1 ✓ BE 12-01-02

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

76603

November-18-11 9:14:18 AM

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 18/11/2011 **Start Qty:** 1.00

*** 1 ***

Cust Item ID:

Required Date: 16/01/2012 **Req'd Qty:** 1.00

*** 1 ***

Customer:

Reference:

Run Start *NR1*

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

200

0.00

200

Skidtubes

0.00

Skidtubes

Skidtubes

Memo

1-remove alodine from around hole and prepare for welding

2-Prep per QSI 005 and Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D3804. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

| Qty | Part Number | Description | Batch |
|-----|--------------|-------------|---------|
| A/R | Aluminum Rod | | m117889 |

3-Grind welds flush as per Dwg D3804.

4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3804. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.

A/RSS Rod NONE BE 12-01-02

5-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D3804. Deburr

04
g the

BE-12-01-02

BB 12/01/02

12-1-3

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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November-18-11 9:14:18 AM

Item ID: D206-642-151 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Replacement Skidtube
 Start Date: 18/11/2011 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 16/01/2012 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|-----------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 210 | HandFinishing | 0.00 | | | | | | | |
| *210* | HandFinish | 0.00 | | | | | | | |
| Hand Finishing | Memo | 0.00 | | | | | | | |
| | Install D2680-041 Nut Plate as per Dwg D3804 | | | | | | | | |
| 215 | QC9- Inspect visual per QSI004- Fusion Welds | 0.00 | | | | | | | |
| *215* | QC | 0.00 | | | | | | | |
| Quality Control | Memo | 0.00 | | | | | | | |
| 220 | QC10- Inspect visual per QSI004- ground welds | 0.00 | | | | | | | |
| *220* | QC | 0.00 | | | | | | | |
| Quality Control | Memo | 0.00 | | | | | | | |

LH

1 12/01/02

12.01.03

8/12/01/03

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

230 QC5- Inspect part completeness to step on W/O 0.00

230

QC

Memo

Quality Control

0.00 8/17/01/03

240 Pressure Wash per QSI005 4.3 0.00

240

HandFinish

Memo

Hand Finishing

0.00

IXD M-L 12/01/03

250 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00

250

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:20 0.00
3200 F
9:50

IXD M-L 12/01/04

W119480

| W/O: | | WORK ORDER CHANGES | | | | | |
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Run Start *NR1*

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Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|-------------------------------------------------------------------------------------------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 260 | QC3- Inspect Part Finish | 0.00 | | | | | | | |
| *260* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 270 | | 0.00 | | | | | | | |
| *270* | HandFinishing | | | | | | | | |
| HandFinish | Memo | 0.00 | | | | | | | |
| Hand Finishing | 1-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D3804. Clean excess adhesive. | | | | | | | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 280 | HandFinishing | 0.00 | | | | | | | |
| *280* | | | | | | | | | |
| HandFinish | Memo | 0.00 | | | | | | | |
| Hand Finishing | ✓ 1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive A/RSikaflex-291 <u>1119508</u> Sikaflex expire date: <u>12/08</u> 2- Install wearplate as per dwg ✓ 2-Wing Walk as per Dwg D3804 and QSI 005 4.4 Batch: <u>1119094</u> | | | | | | | | |
| 290 | QC3- Inspect Part Finish | 0.00 | | | | | | | |
| *290* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

Sikaflex

12/11/11

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 76603***76603***

Page 12

November-18-11 9:14:18 AM

Item ID: D206-642-151

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube

Start Date: 18/11/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 16/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

300

QC5- Inspect part completeness to step on W/O

0.00

300

QC

Memo

0.00

Quality Control

310

Packaging

0.00

310

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-642-151

Location:

PPP Rev: PPP 75754

320

QC21- Final Inspection - Work Order Release

0.00

320

QC

Memo

0.00

Quality Control

12/1/1112/1/11MF 12-01-13

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

November-18-11 9:14:22 AM

Page 1

Work Order ID: 76603

76603

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 18/11/2011

Required Date: 16/01/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 10.12.08 PER IIN REV:N DD VERF:EC
REV:B 11.09.16 PER IIN REV:O DD VERF:EC

IPP

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

D2620

Manufactured

No

110

Each

14.0000

1

1

D2620

Skidtube, 206 Skidtube

**

11/12/22

Location

Loc Qty

Loc Code

LG

14

71616

3

71617

6

74459

2

74460

3

D2647

Manufactured

No

110

Each

253.0000

1

1

D2647

Cap

**

BE 11-12-23

Location

Loc Qty

Loc Code

LG002

253

55352

3

71171

1

73826

139

75482

110

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

November-18-11 9:14:22 AM

Page 2

Work Order ID: 76603

76603

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 18/11/2011

Required Date: 16/01/2012

Start Qty: 1.00

Required Qty: 1.00

CR3212-4-04

Purchased

No

180

Each

15,860.00

52

52

CR3212-4-04

Cherry Rivet

**

SAD 11-12-28

Location

Loc Qty

Loc Code

ST331

5870

116471

78

117816

3

118686

1

118840

16

119017

5762

119075

10

st510

9990

119075

9990

D2654-1

Manufactured

No

180

Each

4.0000

1

1

D2654-1

Web

**

SAD 11-12-28

Location

Loc Qty

Loc Code

LG

4

73794

1

73799

1

75475

1

75477

1

B76756

D3286-1

Manufactured

No

180

Each

175.0000

2

2

D3286-1

Doubler

**

SAD 11-12-27

Location

Loc Qty

Loc Code

LG002

175

74111

1

74441

4

74872

59

75484

111

(2)

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Shop Packet Print

Page 2

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

November-18-11 9:14:22 AM

Page 3

Work Order ID: 76603

76603

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 18/11/2011

Required Date: 16/01/2012

Start Qty: 1.00

Required Qty: 1.00

D2649

Manufactured No

200 Each

461.0000

19

19

D2649

Cross Bolt Spacer

BE 12-01-02
B76793 +19

Location

Loc Qty

Loc Code

LG

134

68224

2

71355

2

72704

2

72841

11

73855

117

LG001

327

65317

1

68507

11

73390

8

73857

21

73858

282

73860

4

D3286-3

Manufactured No

200 Each

153.0000

2

2

D3286-3

Spacer

BE 12-01-02

Location

Loc Qty

Loc Code

LG

72

74870

72

LG001

1

74117

1

LG002

80

75483

80

2

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

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Page 4

Work Order ID: 76603

76603

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 18/11/2011

Required Date: 16/01/2012

Start Qty: 1.00

Required Qty: 1.00

D2680-041

Manufactured No

210 Each

46.0000 1

D2680-041

Nut Plate

**

1 12/01/02

Location Loc Qty Loc Code

LG 1

73334 1

ST020 45

73854 45

CR3212-4-03

Purchased No

210 Each

1,904.000 2

CR3212-4-03

Cherry Rivet

**

2 12/01/02

Location Loc Qty Loc Code

FB 2

110139 2

ST331 1902

114859 902

119017 1000

AN960JD416

NAS1149D0463J

Purchased No

210 Each

0.0000 1

AN960JD416

Washer

CCR264SS3-3

Purchased No

210 Each

1,163.000 2

CCR264SS3-3

Cherry Rivet

**

2 12/01/02

Location Loc Qty Loc Code

FP 2

113973 2

ST311 187

117849 187

ST317 974

119017 974

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Shop Packet Print

Page 4

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 76603

76603

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 18/11/2011

Required Date: 16/01/2012

Start Qty: 1.00

Required Qty: 1.00

MS27039-4-06

Purchased

No

210

Each

384.0000

1

1

MS27039-4-06

Screw

**

12/01/05

Location

Loc Qty

Loc Code

ST291

384

119075

384

D2651-1

Manufactured

No

270

Each

745.0000

6

6

D2651-1

Plug

**

12/01/05

Location

Loc Qty

Loc Code

FP

745

57869

1

66445

10

69018

2

70839

2

71037

31

73827

699

D2651-3

Manufactured

No

270

Each

1,235.000

6

6

D2651-3

O-Ring

**

12/01/05

Location

Loc Qty

Loc Code

FP

1235

61962

12

73489

223

73828

1000

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

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Page 6

Work Order ID: 76603

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

76603

D206-642-151

Start Date: 18/11/2011

Required Date: 16/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3873-1

Manufactured No

280 Each

821.0000 14 14

D3873-1

Bushing

**

u 12/01/05

Location

Loc Qty

Loc Code

ST088

821

B76792

x 14

64760

1

68247

4

73829

19

73830

16

73832

400

75481

381

D2646

Manufactured No

280 Each

235.0000 1 1

D2646

Aft Cap

**

u 12/01/05

Location

Loc Qty

Loc Code

FP002

218

73294

20

73825

198

x 1

FP004

8

68280

5

70945

1

71070

2

FP005

4

71038

4

FP006

5

62678

5

D3805-041

Manufactured No

280 Each

1.0000 1 1

D3805-041

Wearplate Assembly Fwd, Low Gear

**

B75488 Gx1 u 12/01/06

Location

Loc Qty

Loc Code

FP001

1

74893

1

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Shop Packet Print

Page 6

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

Page 7

November-18-11 9:14:22 AM

Work Order ID: 76603

76603

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 18/11/2011

Required Date: 16/01/2012

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-08

Purchased

No

280

Each

1,747.000

2

2

MS27039-1-08

Screw

**

94 12/01/05

Location

Loc Qty

Loc Code

ST291

1747

117423

117

118378

130

118910

500

119075

500

119109

500

v2

MS21042L3

Purchased

No

280

Each

8,753.000

7

7

MS21042L3

Nut

**

94 12/01/05

Location

Loc Qty

Loc Code

ST300

255

117441

16

117885

35

118451

5

118927

199

ST516

6000

119017

6000

ST518

2498

119075

2498

v7

D3805-045

Manufactured

No

280

Each

5.0000

1

1

D3805-045

Wearplate Assembly Aft, Low Gear

**

13 76783 (v1) 94 12/01/05

Location

Loc Qty

Loc Code

FP

5

73817

1

74896

1

74938

3

November-18-11 9:14:22 AM

Shop Packet Print

Page 7

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

Page 8

November-18-11 9:14:22 AM

Work Order ID: 76603

76603

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 18/11/2011

Required Date: 16/01/2012

Start Qty: 1.00

Required Qty: 1.00

AN960JD10L NAS1149D0332I Purchased No

280

Each

0.0000

2

2

AN960JD10I *

Washer

AN3-37A Purchased No

280

Each

1,966.000

7

7

AN3-37A

Bolt

**

1119042(x7) 12/01/05

**

12/01/05

Location

Loc Qty

Loc Code

ST354

4

117619

4

ST518

1962

119086

1962

NAS1149D0363J Purchased No

280

Each

4,434.000

7

7

NAS1149D0363.I

Washer

**

12/01/05

Location

Loc Qty

Loc Code

ST019

16

117505

16

ST295

3000

119537

3000

ST298

1418

117601

148

118077

1

118612

55

118968

1214

12/01/05

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Shop Packet Print

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| ITEM | Qty -041 | Qty -043 | Part Number | Description |
|------|-------------|-------------|--------------|---------------------------------|
| 1 | X | | D3804-041 | SKIDTUBE ASSEMBLY, 206 A/B LOW |
| 2 | | X | D3804-043 | SKIDTUBE ASSEMBLY, 206 A/B HIGH |
| 5 | 1 | 1 | D2600-1-160 | EXTRUSION |
| 6 | 1 | 1 | D2646 | AFT CAP |
| 7 | 1 | 1 | D2647 | CAP |
| 8 | 19 | 20 | D2649 | CROSS BOLT SPACER |
| 9 | 6 | 8 | D2651-1 | PLUG |
| 10 | 6 | 8 | D2651-3 | O-RING |
| 11 | | 1 | D2654-3 | WEB |
| 12 | 1 | | D2654-1 | WEB |
| 13 | 1 | 1 | D2680-041 | NUT PLATE |
| 14 | 2 | 2 | D3286-1 | DOUBLER |
| 15 | 2 | 2 | D3286-3 | STUD |
| 21 | 2 | 2 | AN960JD10L | WASHER |
| 22 | 1 | 1 | AN960JD416 | WASHER |
| 23 | 2 | 2 | CCR264SS3-3 | RIVET |
| 24 | 2 | 2 | CR3212-4-03 | RIVET |
| 25 | 52 | 52 | CR3212-4-04 | RIVET |
| 26 | 2 | 2 | MS27039-1-08 | SCREW |
| 27 | 1 | 1 | MS27039-4-06 | SCREW |

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: 12.5 lb
- 9) WELD PER DART QSI 004
- 10) BENDING: DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 11) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 12) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 76603 M.L.J

11/11/18

RELEASED
09.07.07

per ECN 09-536

| | | | |
|------------|-------------|----|----------|
| A | NEW ISSUE | MB | 08.07.07 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | 91 | | |
| DRAWN | 91 | | |
| CHECKED | 91 | | |
| MFG. APPR. | 91 | | |
| APPROVED | 91 | | |
| DE APPR. | 91 | | |
| DATE | 08.07.07 | | |

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|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------|
| DART AEROSPACE USA, INC PORT HADLOCK, WA | |
| DRAWING NO. D3804 | REV. A SHEET 1 OF 5 |
| TITLE SKIDTUBE ASSEMBLY, 206A/B | SCALE NTS |
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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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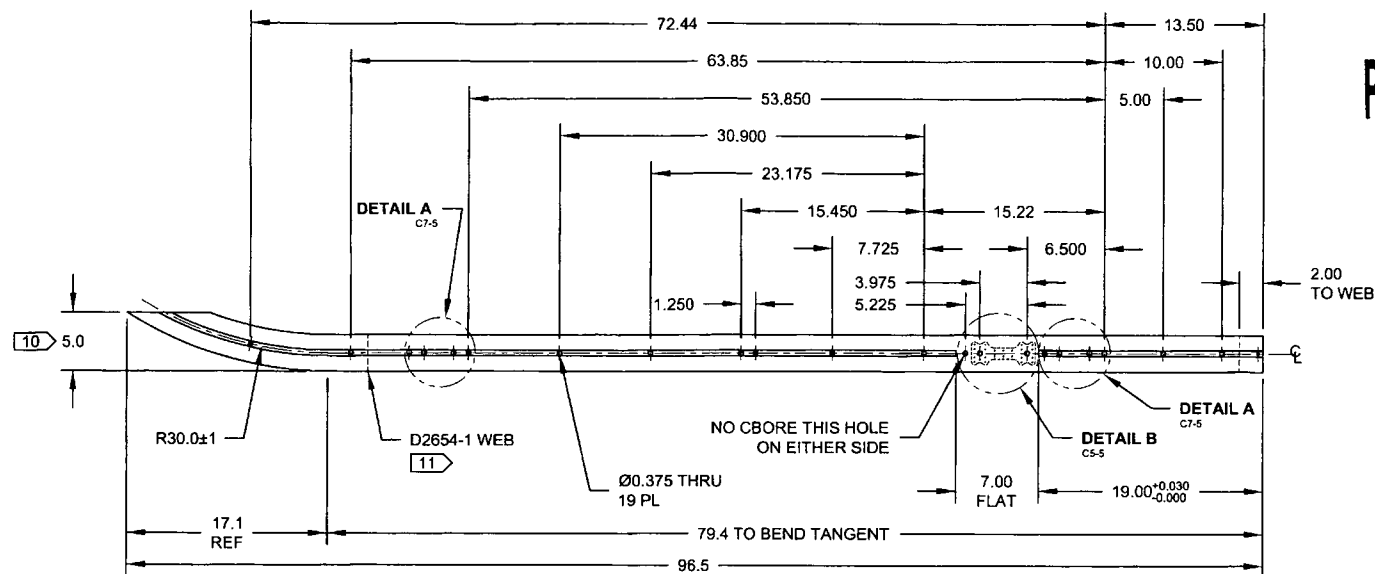
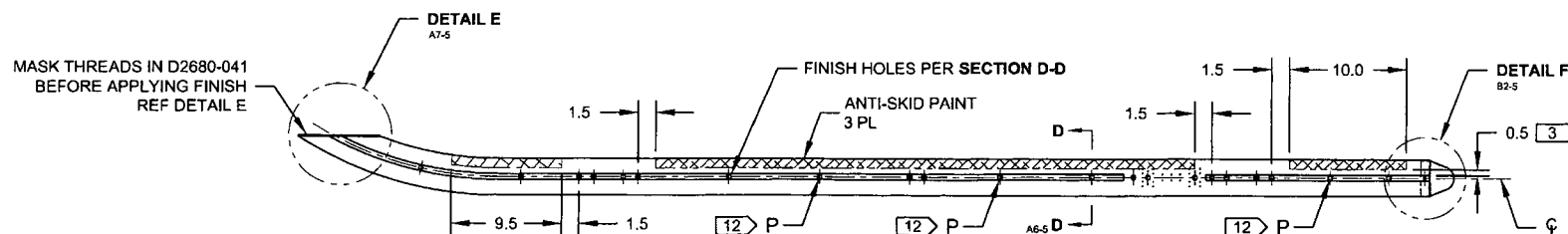
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

76603

RELEASED
09.23.03**D3804-041 BENDING/DRILLING DETAIL****D3804-041 ASSEMBLY/FINISHING DETAIL**

| | | | |
|------------|----------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN | 41 | DART AEROSPACE USA, INC | |
| DRAWN | 41 | PORT HADLOCK, WA | |
| CHECKED | 41 | DRAWING NO. | REV. A |
| MFG. APPR. | 41 | D3804 | SHEET 2 OF 5 |
| APPROVED | 41 | TITLE | SCALE |
| DE APPR. | 41 | SKIDTUBE ASSEMBLY, 206A/B | NTS |
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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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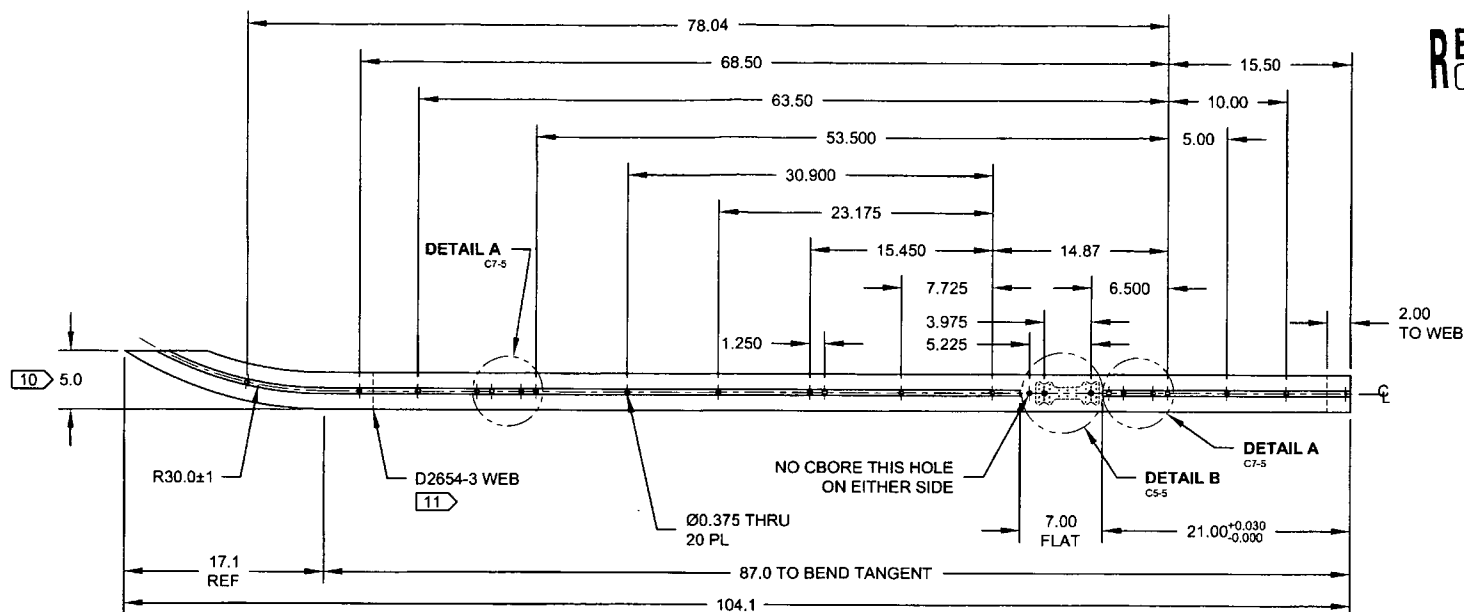
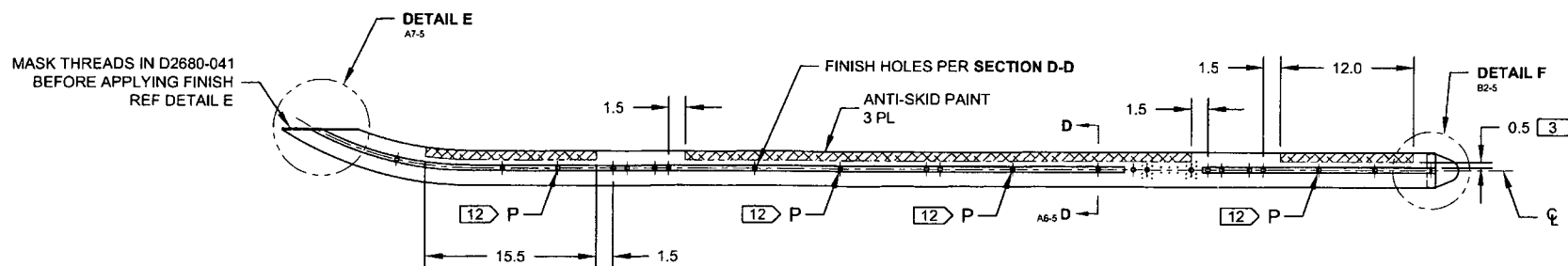
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

76603

RELEASED
09.03.07**D3804-043 BENDING/DRILLING DETAIL****D3804-043 ASSEMBLY/FINISHING DETAIL**

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| DESIGN | 97 | DART AEROSPACE USA, INC | |
| DRAWN | 97 | PORT HADLOCK, WA | |
| CHECKED | 97 | DRAWING NO. | REV. A |
| MFG. APPR. | 97 | D3804 | SHEET 3 OF 5 |
| APPROVED | 97 | TITLE | SCALE |
| DE APPR. | 97 | SKIDTUBE ASSEMBLY, 206A/B | NTS |
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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

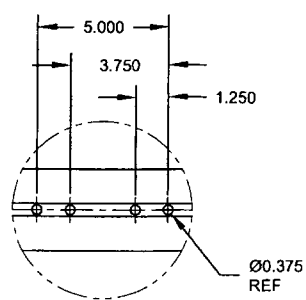
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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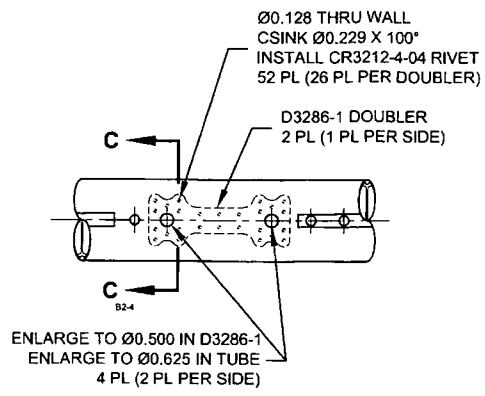
NOTE: Date & initial all entries

76603

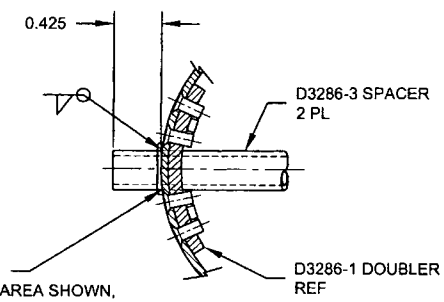
RELEASED
09.03.03



DETAIL A
SCALE NONE
D6-2
C2-2
D6-3
C2-3

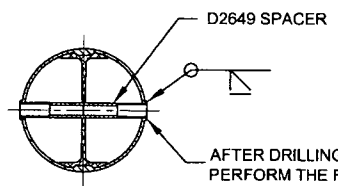


DETAIL B
SCALE NONE
C3-2
C3-3



- TO INSTALL D3286-1/3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH OUTSIDE SURFACE OF ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.03 X 45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE AND GRIND FLUSH

SECTION C-C
PARTIAL SECTION
SCALE NONE
C6-4



- AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.03 X 45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. CBORE TO Ø0.313 X 0.75 DP (EXCEPT WHERE INDICATED)

SECTION D-D
FOR Ø0.375 HOLES ONLY
SCALE NONE
A4-2
A4-3

| | | | |
|------------|----------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN | 97 | DART AEROSPACE USA, INC | |
| DRAWN | 5 | PORT HADLOCK, WA | |
| CHECKED | 8 | DRAWING NO. | REV. A |
| MFG. APPR. | 8 | D3804 | SHEET 4 OF 5 |
| APPROVED | 12 | TITLE | SCALE |
| DE APPR. | 12 | SKIDTUBE ASSEMBLY, 206A/B | NTS |
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

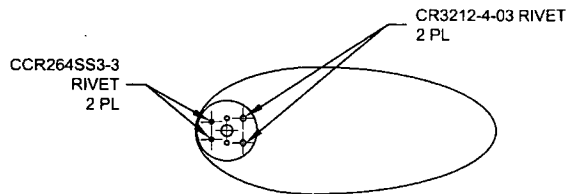
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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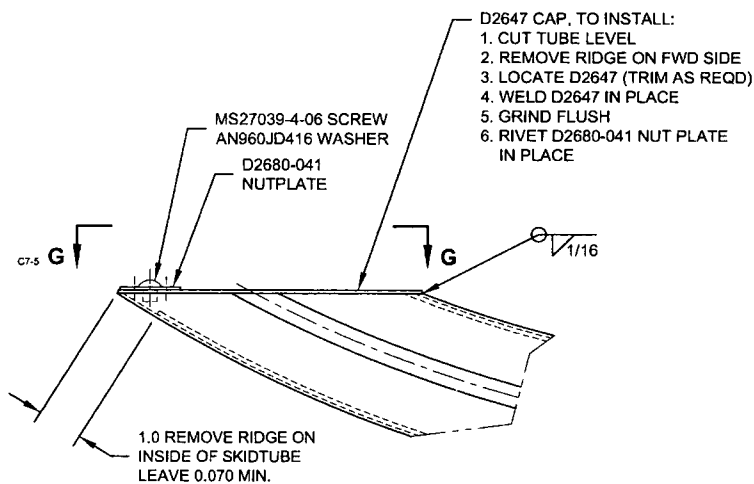
NOTE: Date & initial all entries

76603

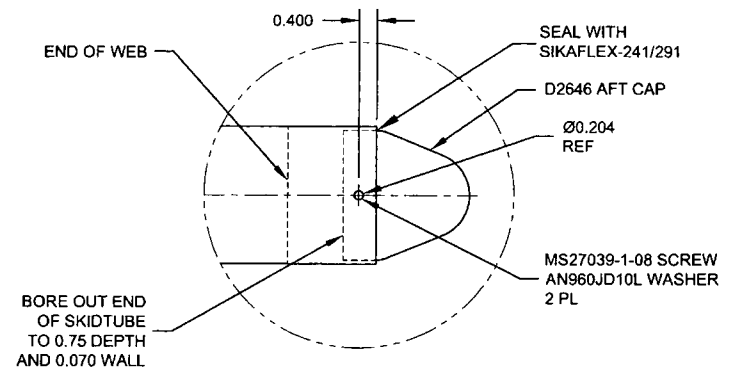
RELEASED
07.07.07



VIEW G-G
SCALE NONE
A7-5



DETAIL E
SCALE NONE
B7-2
B7-3



DETAIL F
SCALE NONE
B2-2
B2-3

| | | | |
|------------|----------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN | 97 | DART AEROSPACE USA, INC | |
| DRAWN | 97 | PORT HADLOCK, WA | |
| CHECKED | 97 | DRAWING NO. | REV. A |
| MFG. APPR. | 97 | D3804 | SHEET 5 OF 5 |
| APPROVED | 97 | TITLE | SCALE |
| DE APPR. | 97 | SKIDTUBE ASSEMBLY, 206A/B | NTS |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

NO. 278

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: 766119
Part number: 206-642-151
Description: 206 skid tube
Welding Process: Tig ☒ Mig ☐
Base material: Aluminum
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐
Undercut: pass ☒ fail ☐
Pin holes: pass ☒ fail ☐
Overlap (cold lap): pass ☒ fail ☐
Porosity (surface): pass ☒ fail ☐
Coloration: pass ☒ fail ☐

Qualifier Pat. Dunn Date of Test Coupon 11-12-20
Welder Barclay Elliot Date of Test Coupon 11-12-20

The above named individual is qualified in accordance with AWS D17.1.2001 to weld